

SPLIT

Date: Friday, 9/29/2006 10:43:44 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 28794	
Estimate Number : 12451	
P.O. Number : N/A	Part Number : D35001
This Issue : 9/29/2006 S.O. No. : N/A	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 28477	Material : N/A
	Due Date : 10/30/2006
Written By : <u>JA</u>	Qty: 30 Um: Each
Checked & Approved By : <u>JA 06 09 29</u>	
Comment : Est Rev:A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	6061-T6 7.0x6.5x2.0
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
6061-T6 7.0x6.5x2.0
350 Saddle Billet
Batch: B28289

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. SD Double check by: JL

- 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
- 4-Deburr
- 5-Tumble to remove sharp edges.

SD/JL 06/10/05 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/JL 06/10/05 20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 06/10/05 20

Date: Friday, 9/29/2006 10:43:44 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 28794

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

yl 06/10/06 x 20

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575 yl 06/10/12 x 20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 06/10/13 (x20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 348 ml 06/10/13 (x20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 06/10/10 (20)

Job Completion



u 06.10.13

DART AEROSPACE LTD		Work Order:	28794
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.375	.376	.375		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		R.525	R.525	R.525	R.525		
I	R1.575	R1.595		1.586	1.584	1.583	1.582		
J	0.240	0.260		.248	.247	.249	.248		
K	0.490	0.510		.500	.500	.499	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.319	.315	.319	.318		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.505	6.503	6.504	6.503		
P	5.990	6.010		5.995	5.996	5.997	5.996		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.547	.545	.546	.547		
V	0.793	0.803		.798	.798	.798	.797		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.136	1.134	1.133	1.132		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.256	.257	.256		
AE	1.810	1.830		1.820	1.8215	1.821	1.820		
AF	0.240	0.260		.252	.251	.251	.249		
AG	0.140	0.160		.151	.151	.150	.150		
AH	0.140	0.160		.150	.150	.151	.151		
AI	0.140	0.160		.153	.153	.153	.152		
Accept/Reject									

Measured by:	SD
Date:	06.10.03

Audited by:	gml
Date:	06/10/05

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	[Signature]

1944

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88

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DART AEROSPACE LTD		Work Order:	28794
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.186		
C	3.145	3.155		3.150	3.150	3.150	3.156		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.499	.500		
H	R.470	R.530		R.525	R.525	R.525	R.525		
I	R1.575	R1.595		1.583	1.584	1.582	1.583		
J	0.240	0.260		.248	.247	.250	.250		
K	0.490	0.510		.498	.498	.499	.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.319	.319	.319	.319		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.508	6.509	6.508	6.507		
P	5.990	6.010		6.000	6.000	6.000	5.999		
Q	2.820	2.830		2.823	2.823	2.823	2.823		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.546	.547	.546	.546		
V	0.793	0.803		.797	.798	.797	.798		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.134	1.132	1.133		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.256	.256	.256		
AE	1.810	1.830		1.818	1.819	1.819	1.818		
AF	0.240	0.260		.251	.251	.250	.250		
AG	0.140	0.160		.150	.151	.150	.150		
AH	0.140	0.160		.153	.153	.150	.153		
AI	0.140	0.160		.153	.152	.154	.153		
Accept/Reject									

Measured by: <u>SD</u>	Audited by: <u>me</u>
Date: <u>06/10/03</u>	Date: <u>06/10/05</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	<u>[Signature]</u>

DART AEROSPACE LTD		Work Order: 28794
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.375	.375	.375		
F	0.490	0.510		.498	.498	.496	.498		
H	R.470	R.530		R.525	R.525	R.525	R.525		
I	R1.575	R1.595		R1.582	1.583	1.584	1.584		
J	0.240	0.260		.251	.248	.250	.249		
K	0.490	0.510		.500	.500	.500	.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.319	.319	.319	.318		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.508	6.508	6.507		
P	5.990	6.010		6.000	6.001	6.001	5.999		
Q	2.820	2.830		2.825	2.825	2.823	2.825		
R	2.495	2.505		2.500	2.500	2.508	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.547	.547	.547	.547		
V	0.793	0.803		.797	.798	.798	.798		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.132	1.133	1.134	1.133		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.258	.257	.256	.256		
AE	1.810	1.830		1.820	1.820	1.819	1.819		
AF	0.240	0.260		.250	.252	.257	.251		
AG	0.140	0.160		.150	.151	.151	.151		
AH	0.140	0.160		.152	.153	.153	.153		
AI	0.140	0.160		.153	.153	.153	.153		
Accept/Reject									

Measured by: SD
Date: 06.10.04

Audited by: gnd
Date: 06/10/05

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	28794
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.376	.374	.375		
F	0.490	0.510		.499	.500	.500	.500		
H	R.470	R.530		R.525	R.525	R.525	R.525		
I	R1.575	R1.595		1.583	1.583	1.584	1.584		
J	0.240	0.260		.250	.249	.247	.250		
K	0.490	0.510		.499	.499	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.319	.319	.319	.319		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.509	6.509	6.509		
P	5.990	6.010		6.001	6.000	6.000	6.001		
Q	2.820	2.830		2.823	2.823	2.823	2.823		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.123	1.123	1.123	1.123		
U	0.540	0.560		.548	.549	.547	.547		
V	0.793	0.803		.798	.797	.798	.798		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.134	1.134	1.134	1.133		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.255	.256	.257	.256		
AE	1.810	1.830		1.820	1.818	1.820	1.820		
AF	0.240	0.260		.251	.250	.251	.251		
AG	0.140	0.160		.151	.150	.151	.151		
AH	0.140	0.160		.153	.153	.152	.152		
AI	0.140	0.160		.153	.153	.152	.153		
Accept/Reject									

Measured by:	SD
Date:	06.10.04

Audited by:	gml
Date:	06.10.05

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	28794
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.181		
C	3.145	3.155		3.149	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.179	1.180		
E	0.365	0.385		.375	.375	.376	.375		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.585	1.584	1.586		
J	0.240	0.260		.248	.250	.251	.253		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.318	.318	.318	.318		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.509	6.509	6.508		
P	5.990	6.010		5.998	5.996	5.997	5.998		
Q	2.820	2.830		2.825	2.826	2.825	2.824		
R	2.495	2.505		2.500	2.500	2.500	2.499		
S	2.245	2.255		2.250	2.250	2.250	2.249		
T	1.120	1.130		1.125	1.125	1.126	1.124		
U	0.540	0.560		.551	.550	.550	.550		
V	0.793	0.803		.798	.798	.797	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.136	1.136	1.135	1.137		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.258	.257	.257		
AE	1.810	1.830		1.821	1.820	1.821	1.821		
AF	0.240	0.260		.251	.252	.251	.253		
AG	0.140	0.160		.150	.150	.151	.152		
AH	0.140	0.160		.153	.152	.153	.152		
AI	0.140	0.160		.151	.152	.153	.151		
Accept/Reject									

Measured by:	JL
Date:	06/10/05

Audited by:	gml
Date:	06/10/05

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	



